

Work Order ID 61699

Tuesday, August 31, 2010 1:18:55 PM



Page 1

Item ID: D3564-5

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 8/31/2010

Start Qty: 10.00



Cust Item ID:

Required Date: 9/7/2010

Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: *H*Date: *10-8-31*

Tooling:

Date:

Run Start



QC: _____

Date: _____

SPC (Y/N):

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3564	Rev D

100



FLOW WATER JET

Waterjet

Memo

0.00

10-9-8

FLOW CNC Waterjet

*304 .063*1-Cut as per Dwg D3564 Dwg Rev: *D* Prog Rev: *D* 2-
Deburr if necessary*(8)*

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

10-9-8

Quality Control

120



QC8- Inspect parts - second check

0.00

QC

Memo

0.00

10/09/09

Quality Control

(x8)

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Page 2

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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



NC BRAKE

0.00

(8)

Brake NC

Memo

0.00

Brake NC

Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT8179 and DT8155 Form Joggle as per Dwg D3564 on brake using Jig DT8157

SB 10/09/09

140



QC5- Inspect part completeness to step on W/O

0.00

S.10/09/09

Quality Control

Memo

0.00

QC

Ensure joggle as per dwg D3429

(8)

150



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

6/16-9-10

Powdercoat

Memo

0.00

Powder Coating

START TIME:

320

10:20

OVEN TEMPERATURE:

FINISH TIME:

10:00

(8)

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Picklist Print

Tuesday, August 31, 2010 1:18:59 PM

Page 1

Work Order ID: 61699



Parent Item: D3564-5



Parent Item Name: Wearshoc

Start Date: 8/31/2010

Required Date: 9/7/2010

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev:A New Issue 07-03-08 ec
IPP Rev:B As per Rev C 07-07-09 JLM
IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC
IPP Rev D added DT# 08.04.21 DD Verified by EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 		Purchased		No		100	sf	82.9000	1.5	15.78947	<i>not enough!</i>	<i>1B 109-8</i>	

304/316 Sheet .063

Location	Loc Qty	Loc Code
MAT20	82.9	
115440	82.9	<i>(8)</i>

115440

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DART AEROSPACE LTD	Work Order:	61699
Description: Wearshoe	Part Number:	D3564-5
Inspection Dwg: D3564	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>BS</u>	Audited by: <u>S</u>	Prototype Approval: N/A
Date: <u>10-9-08</u>	Date: <u>10/09/08</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/EC/DD	DS

W/O:		WORK ORDER CHANGES					
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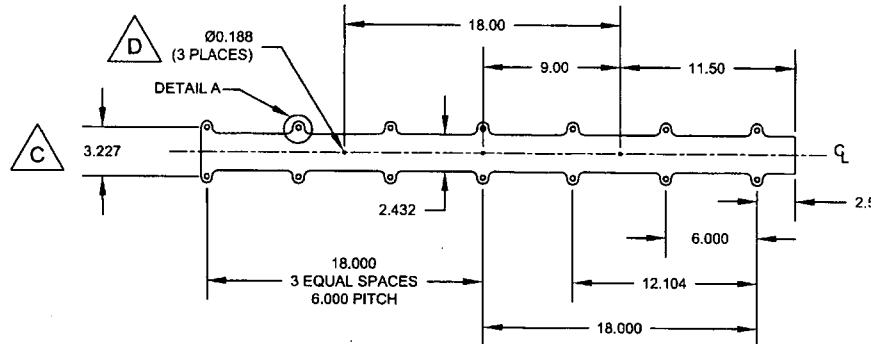
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8 7 6 5 4 3 2 1

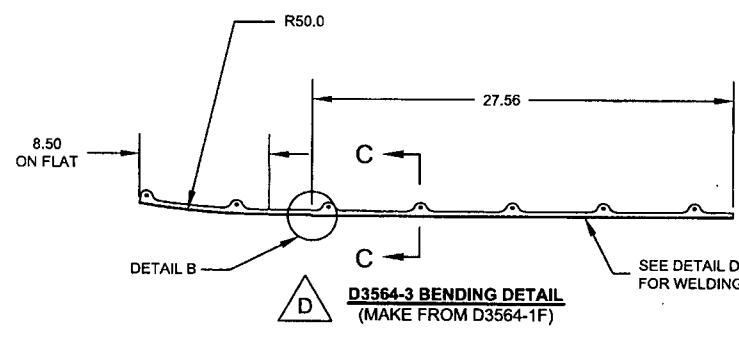
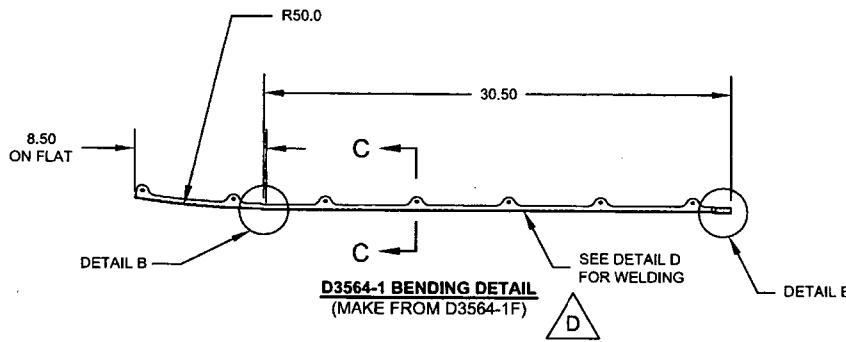


SHOP DRAWING
RETURN TO
ENGINEER
UNCONTROLLED
SUBJECT TO AMEND
WITHOUT NOTICE
WORK ORDER
NO. *111-99*
B810-8-31

RELEASED

07.09.04 *ft*

D3564-1F FLAT PATTERN



D3564-1/3-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT C

WEIGHTS:	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	SI	D3564	SHEET 1 OF 3
APPROVED	SI	TITLE	SCALE
DE APPR.	SI	WEARSHOE	1:8
DATE	07.08.21	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

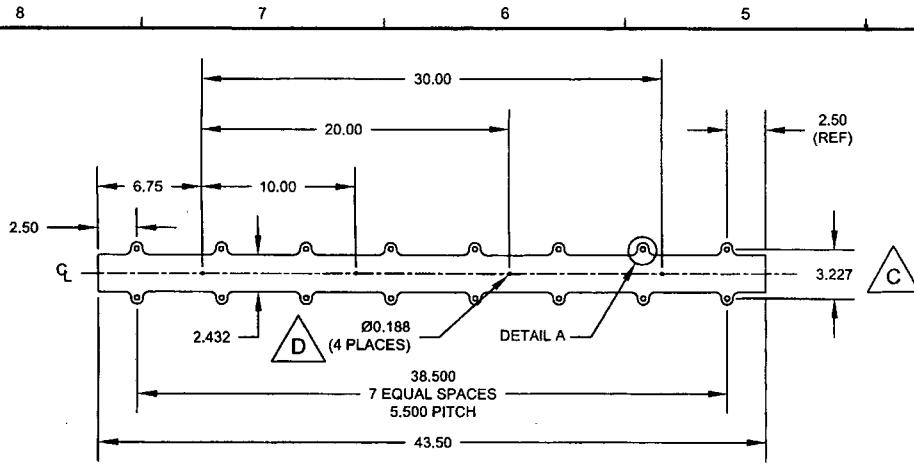
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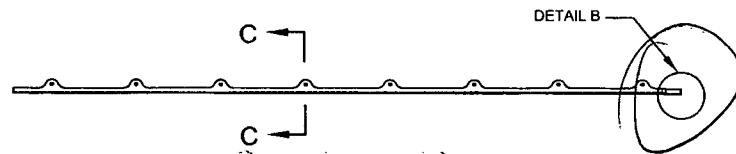
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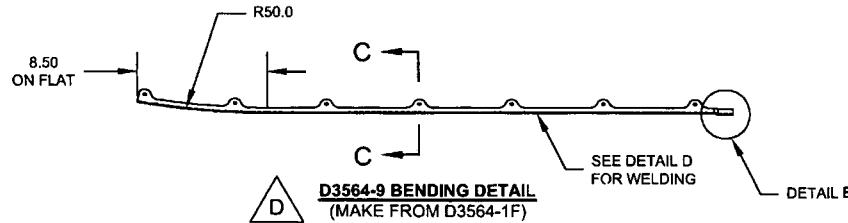
NOTE: Date & initial all entries



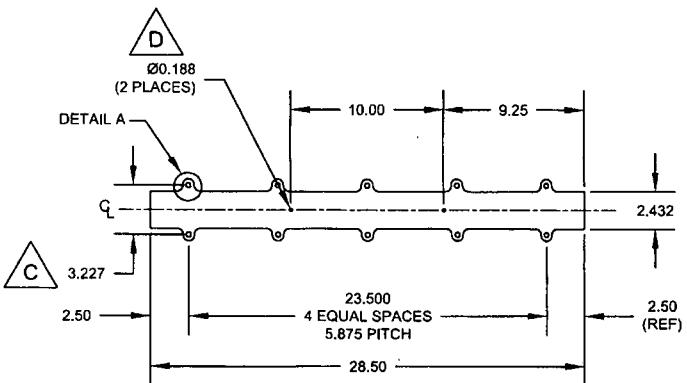
D3564-5F FLAT PATTERN



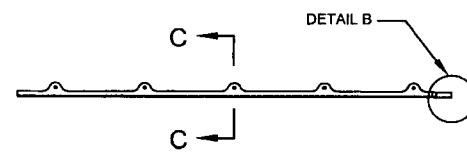
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)

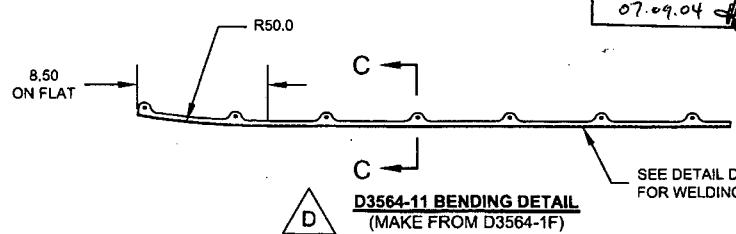


D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)

alo 66699



D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	SI	D3564	SHEET 2 OF 3
APPROVED	ND	TITLE	SCALE
DE APPR.	SH	WEARSHOE	1:8
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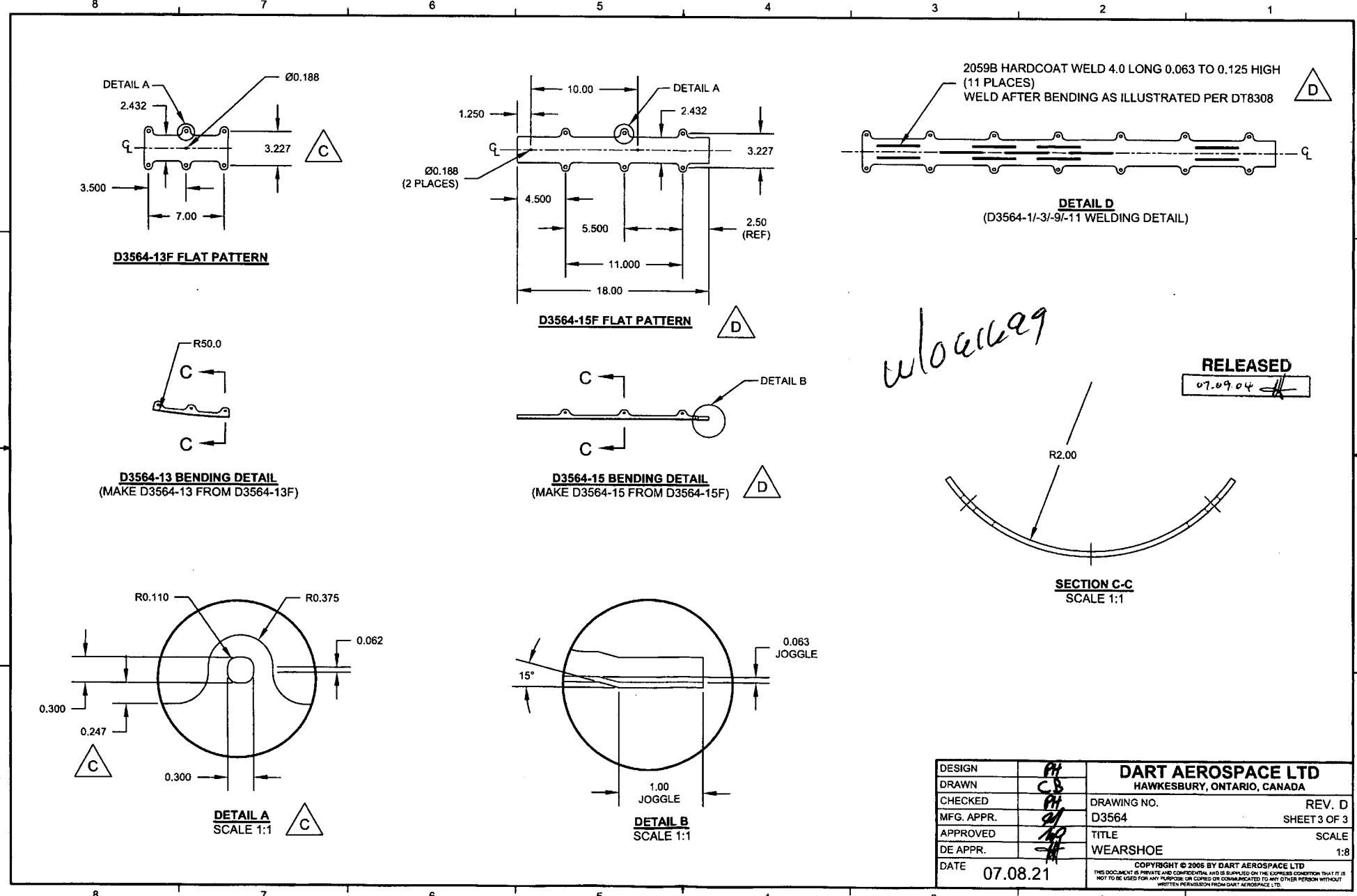
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CHECKED	PH	REV. D
MFG. APPR.	PH	DRAWING NO.
APPROVED	PH	D3564
DE APPR.	PH	SHEET 3 OF 3
DATE	07.08.21	SCALE
		WEARSHOE

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